

Work Order ID 61105

Friday, August 06, 2010 9:50:27 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/6/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-8-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

PL 10-8-04

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

(IX) Q MS 10-08-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

x1 0 8E10/08/15

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/06/15

(N)

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M114677

BE 10/08/26

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M114677

BE 10/08/26

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/08/31

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/6/08/31

Memo

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/6/08/31

Memo

0.00



170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 16/10/08

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
	Memo	0.00							
	START TIME: 11:05								
	OVEN TEMPERATURE: 300								
	FINISH TIME: 11:35								
190	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control	0.00							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

=> M 10/09/08

1 0

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M115114 ☐ ☐

Sikaflex expire date: 11/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M115114 ☐ ☐

Sikaflex expire date: 11/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 11105028

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

8/10/09/09

(40)

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPD 6 0923

C 10/2/10 C

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/13

C 10/9/13

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Friday, August 06, 2010 9:50:31 AM

Page 1

Work Order ID: 61105

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010


Required Date: 8/19/2010

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:N02.08.280FP was QC5 in Step 27; Added QC5 to Step 300KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1		Manufactured	No			110	Each	4.0000	1	1			
													
205 Skidtube bent detail													

Location	Loc Qty	Loc Code
LG	1	
57028	1	
ST046	3	
59856	2	
59913	1	

D2576-3		Manufactured	No			140	Each	84.0000	1	1			
													
Step (maching detail)													

Location	Loc Qty	Loc Code
LG	84	
46661	36	
52215	48	

D2579		Manufactured	No			140	Each	327.0000	20	20			
													
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG	327	
57052	5	
57348	4	
58433	2	
59113	182	
60845	134	

PS 6095 MB 10-08-19

1 BE 10/08/20

20 BE 10/08/20

Dart Aerospace Ltd

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Page 2

Work Order ID: 61105

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

81.0000

1

1



Cap



YH 10/09/08

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

80

50513

1

50770

28

51539

2

53791

49

YH 10/09/08

AN3-5A

Purchased No

200 Each

1,542.000

2

2



Bolt



YH 10/09/08

Location

Loc Qty

Loc Code

ST350

1542

105057

542

115016

500

115371

500

YH 10/09/08

AN960JD10L

NAS1149D0332J Purchased

No

200 Each

2,633.000

2

2



Washer



YH 10/09/08

Location

Loc Qty

Loc Code

ST348

2633

110985

2633

YH 10/09/08

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Page 2

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Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

878.0000

50

50



Insert



10/09/08

Location

Loc Qty

Loc Code

FP 1114723 861

115079 861

ST282 17

113238 17

x50

AN3C4A

Purchased

No

200

Each

1,889.000

50

50



BOLT



10/09/08

Location

Loc Qty

Loc Code

ST350 1889

114108 14

114416 12

114523 2

114941 861

115300 1000

1115438

x50

AN960C10L

NAS1149C0332
R

Purchased

No

200

Each

29.0000

50

50



washer



10/09/08

Location

Loc Qty

Loc Code

ST245 29

107534 29

x50

1115000

Friday, August 06, 2010 9:50:32 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/19/2010


Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 33.0000 1 1

 Gasket


Location	Loc Qty	Loc Code
FP	2	
53461	2	
FP012	31	B54660
59661	23	
60209	8	

yl 10/09/08

D3566-5 Manufactured No 200 Each 36.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP	22	
60869	22	/
FP015	14	
59158	14	

yl 10/09/08

D3566-1 Manufactured No 200 Each 30.0000 2 2

 Gasket

Location	Loc Qty	Loc Code
FP	13	
60857	13	
FP015	17	
57715	2	
59126	3	
60202	12	

B61656

yl 10/09/08

Friday, August 06, 2010 9:50:32 AM

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Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11

Manufactured No

200

Each

8.0000

1

1



Wearshoe



10/09/08

Location

Loc Qty

Loc Code

FP019

8

59941

8

D3564-13

Manufactured No

200

Each

31.0000

1

1



Wearshoe



10/09/08

Location

Loc Qty

Loc Code

FP17

31

59660

19

60862

12

D3564-9

Manufactured No

200

Each

24.0000

1

1



Wearshoe



10/09/08

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

23

59201

10

60236

13

10/09/08

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Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

27.0000

1

1



Wearshoe



10/09/08

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

24

59157

11

60868

13

x1

D2594-3

Manufactured No

200

Each

379.0000

16

16



O-Ring, 205 Skidtube



10/09/08

Location

Loc Qty

Loc Code

FP

379

55546

19

58191

12

59358

348

x16

D2594-1

Manufactured No

200

Each

419.0000

16

16



Plug, 205 Skidtube



10/09/08

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

236

58434

47

59110

189

x16

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERNO. 01105
*PS 10-8-04***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

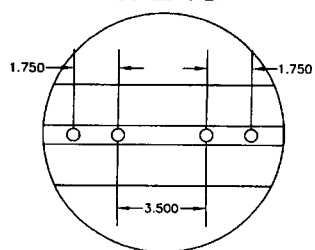
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

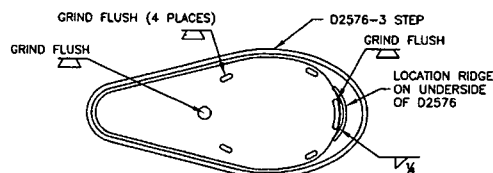
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

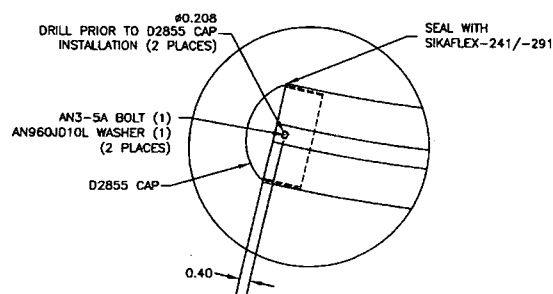


DETAIL B
SCALE 5:24

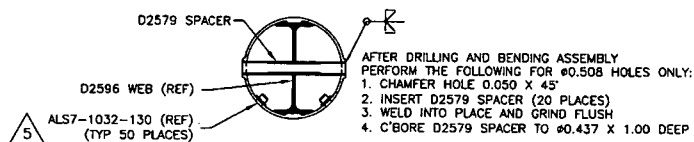


RELEASED
07-06-28

DETAIL C
SCALE 5:24



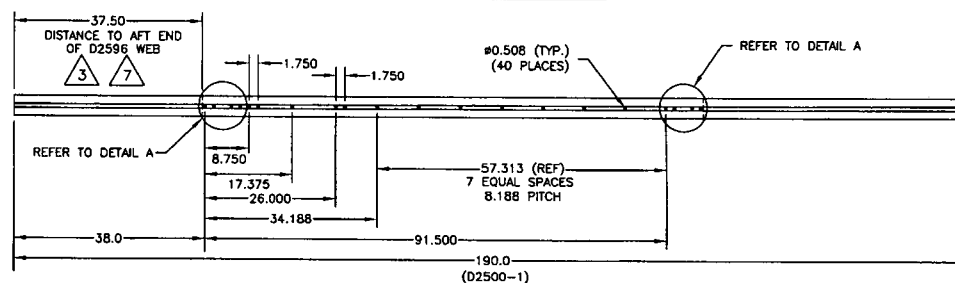
SECTION D-D
SCALE 5:24



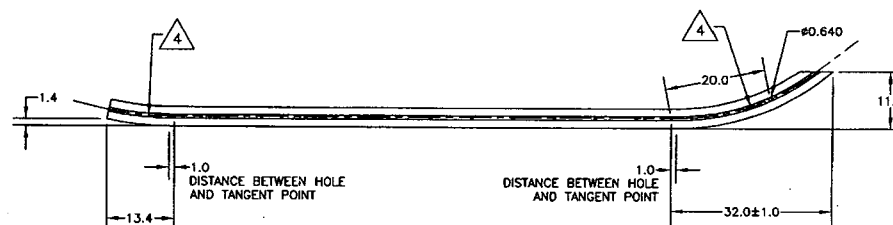
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

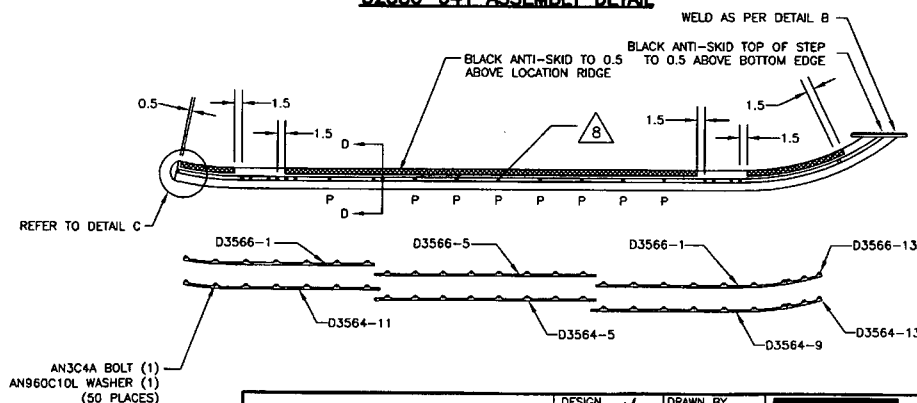
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	11
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DRAWN BY

CHECKED *ll*

APPROVED

DATE _____

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2580

DTLF :

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 2 OF 3

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 238

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61352
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier: Ped. Dahl Date of Test Coupon 10.08.25
Welder: Barclay Elliott Date of Test Coupon 10.08.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld